Dart Aerospace Ltd. Monday, 12/11/2006 12:53:55 PM User: **Process Sheet** : TUBE ASSEMBLY Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 29845 **Estimate Number** : 11925 Al4: : D2003107 **Part Number** P.O. Number UNDER REVIEW (B 06.12.11 S.O. No. : No : 12/11/2006 **Drawing Number** This Issue SEE NOTE ON DWG : N/A Prsht Rev. Project Number First Issue Type : SMALL /MED FAB **Drawing Revision** Material **Previous Run** : 1/15/2007 5 Um: **Due Date** Qty: Each Written By Checked & Approved By Re-format EC Comment **′**99.11.11 **Additional Product** Job Number: Description: Seq. #: 606 (T6T03756025 304 TUBING-Comment: Qty.: 5.3592 f(s) 1.0718 f(s)/Unit Total: 304 TUBING Cut: 12.25" long as per Dwg D2003 FF 07.01.02 Material:3/8"Æ x 0.035" wall 6061-T6 tubing Batch: # 17666 M26506 Firesleeve-crkl .375IDia Comment: Qty.: 1.1156 f(s)/Unit Total: 5.5781 f(s) Cut: 12.75" long as per Dwg D2003 Material: M2650-6 Heat sleeve Batch: m 175a 07-01-09 MS208196D Sleeve 3.0 Total: Comment: Qtv.: 2.0000 Each(s)/Unit 10.0000 Each(s) Sleeve **Qty Part Number** 9-M103044 AN8186D

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut Pick:

Qty Part Number Description Batch
2 AN818-6D Nut 17651

MF. 02-01-69

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES												
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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Part No:	PAR #:	Fault Category: _	19.1	NCR: Yes No	DQA:	Date: <u>ح</u>	7/00/6
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
DATE		Description of NC		Corrective Action Section B	Verification	Approval	Ammrayal							
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NOTE: Date & initial all entries

Date: Monday, 12/11/2006 12:53:55 PM Úser: Kim Johnston **Process Sheet** Drawing Name: TUBE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 29845 Part Number: D2003107 Job Number: Seq. #: Description: Machine Or Operation: 5.0 D2182045 Heat Shrink 4.5" Long Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Heat Shrink Pick: **Qty Part Number** Description Batch 1 D2182-045 Heat shrink SMALL & MEDIUM FAB RESOURCE 1 6.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Form tube as per template D2003-107 Assemble as per Dwg D2003 ---INSPECT WORK TO CURRENT STEP QC5 7.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 57 0/4 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE M 276/112 Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Part No	:	PAR #: Fault Category: NC	R: Yes	s No DQ	<b>A</b> :	Date:						

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: _	
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C							
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NOTE: Date & initial all entries





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4	16	L #7	D2003 SHEET 1 OF 2
DATE			TITLE SCALE
99.0	06.08		206 CABIN HEATER TUBE ASSEMBLIES NTS
Α		90.04.09	NEW ISSUE
В		99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)

RELEASED 44.06.08 KED

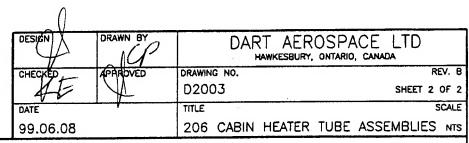
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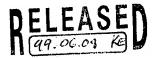
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		NG A	E	MS20819-8J	AN818-8J NUT	MS20819-8D	AN818-8D NUT	320	AN818-6D		NO	VENDOD OD	
		HEATSLEEVE LENGTH <sup>1</sup>	CUT LENGTH OF TUBE <sup>2</sup>	×	¥	ž	F	×	F	DESC.	MATERIAL 4/8/7	VENDOR OR SPEC	
P/N	TEMPLATE		ļ					_	<del> </del>	<del></del>	6061-T6 0.375 OD x 0.035 W		
D2003-001	T2003-001	5.2	6.00	ļ			<u> </u>	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6 WW-T-700/6	
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-005	T2003-005	9.8	10.62		ļ			2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-007	T2003-007	20.0	19.63		<u> </u>	<del>                                     </del>			2		6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-009	T2003-009	12.38	12.44				<u> </u>	2	2	TUBE ASS'Y TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-011	T2003-011	33.31	32.38		-			2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-013	T2003-013	12.7 17.2	13.54 18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-015	T2003-015 T2003-017	17.2	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-017 D2003-019	T2003-017	9.8	10.62			2	2	- 2	-	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6	
D2003-019 D2003-021	T2003-019	9.6 N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	VVV-T-700/6	
D2003-021	T2003-021	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6	
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6	
D2003-023	T2003-025	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6	
D2003-027	T2003-027	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6	
D2003-023	T2003-025	14.6	15.38	2	2	<del>-</del>		<b></b>		TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-031	T2003-033	29.75	29.62	2	2				<del> </del>	TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-037	T2003-037	24.81	23.38	2	2	7				TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-047	T2003-047	5.56	5.56	2	2		- 1			TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304	
D2003-077	T2003-077	N/A	6.25					1	1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6	
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6	
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6	
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6	
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6	
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6	
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX	
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX	
D2003-14	T2003-14	4.0			]					HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX	
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX	
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	_6061-T6 0.375 OD x 0.035 W	WW-T-700/6	
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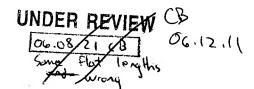
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## Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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